

5/35

DART AEROSPACE LTD		Work Order:	23972
Description: Basket Lid Assembly		Part Number:	D2989-041
			D2989-043
Drawing: D2989 Rev A23		Qty:	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveler Dwg not required	Hy	05.08.08	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. Batch: <u>M17213</u> Cut Qty. 4 D2236-1 from: Qty. 1 D3166-3 Batch: <u>B23312</u> Note: D3166-3 included in D2989-041 Bom	W	05/08/12	1
3	WS	Drill holes in tubing as D2989-041 per Dwg D2989	AD	05/08/12	1
4	WS	Deburr: <i>Remove all markings on material</i>	AD	05/08/12	1
5	WS	Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required Pick: Only apply for D2989-041 BOM. Qty Part number Description Batch 2 D2581 Mounting Brackets <u>B23310</u> 2 D2327-3 Bushing <u>B23447</u> 1 D2506 Label Plate <u>B23851</u> 15sf M304EX0.75-16F Expanded Metal <u>M18074</u> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.	W	05/08/15	1
6	WS	Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041	AD	05/08/15	1
7	WS	Drill holes in tubing as D2989-043 per drawing D2989	AD	05/08/15	1
8	WS	Deburr: <i>Remove all markings on material</i>	AD	05/08/15	1
9	WS	Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required. Pick: Only apply for D2989-043 BOM. Qty Part number Description Batch 2 D3182-1 Hinge <u>B22085</u> 8 sf M304EX0.75-16F Expanded Metal <u>M18074</u> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid. Identify as D2989-043	W	05/08/16	1
10	QC9 & 6	Inspect D2989-041/-043 Weld and Dimensions	J	05.08.16	1
11	FP	Powder Coat White (Ref. 4.3.5.2) D2989-041/-043 as per QSI 005 4.3 & Dwg D2989	ML	05.08.17	1
12	FP	Wing walk D2989-041 only as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: <u>M17746</u> Wing Walk: <u>M17829</u>	ML	05.08.18	1
13	QC3	Inspect Powder Coat and Wing Walk	U	05.08.18	1
14	FP	To GA Cell for Assembly	SAD	06/08/18	1

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	01.11.29	Revised Pick List (NCR 589)	SM	
C	02.05.11	Clarify step 5	NG	
D	02.07.24	Re-format; Modify Step 2	KJ	
E	02.08.15	D3166-3 was D3166-1	KJ	
F	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ	
G	03.01.31	Incorporated D2989-043	KJ/RF	

RELEASED
03.02.05 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-08-16	9	Add 2x D3442-5 to pick list (Shims for hinge). Shim batch is m17551 permanent change		05/08/16	2		 05-08-16

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____